

adopted in the vulcanization-molding machine easily. Further, volume of space at a part of the carved groove not overlapping with a lug groove formed by the lug groove rib can be made so small that the space can be filled with a rubber flowing into it easily on vulcanization-molding. Thus, wrinkles caused by the space not filled with the rubber can be restrained effectively to improve appearance of the tire.

IN THE CLAIMS:

Please cancel claim 7 without prejudice and/or disclaimer.

Please enter the following amended claim:

2 Sub 1
1. (Twice Amended) A method for manufacturing a pneumatic tire in which a green tire having tire components assembled is charged in a mold for vulcanization-molding and lug grooves are formed on a tire tread surface within the mold by lug groove ribs provided on an inner surface of the mold, said method including previously forming carved grooves at positions on a tread surface of said green tire corresponding to said lug grooves such that the carved grooves extend in substantially the same direction as said lug grooves and that each of the carved grooves has substantially a triangular shape that is different from the shape of said lug groove ribs and widens gradually from a side of a tread center to a side of a tread end, said triangular shape preventing interference and pressing of the lug groove ribs with and against the tread surface of the green tire, while ensuring smooth insertion of the lug groove ribs into the carved grooves, respectively, when the green tire is being introduced into the mold.

C3 *Sub D* 8. (Amended) A method for manufacturing a pneumatic tire as claimed in claim 1,
wherein said carved groove having the shape gradually widening is formed by carrying out the
carving twice using a cutter.

Cd 17. (Twice Amended) A method for manufacturing a pneumatic tire, comprising:
a step of manufacturing a green tire in which extruded rubber having the shape of a
ribbon or a sheet is piled up on a ply and a belt member assembled on a drum to form a tread;
a step of forming a carved groove on a tread surface of said green tire in direction of a lug
groove; and
a step of charging said green tire formed with said carved groove in a vulcanization-
molding machine to carry out vulcanization-molding so as to form a vulcanized tire having the
lug groove, which is formed by a lug groove rib of the vulcanization-molding machine;
wherein the carved groove has a shape that is different from the shape of the lug groove
rib.